

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011850**Date Inspected:** 09-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Shrikant Utekar was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 6AE

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

Ultrasonic Testing (UT) performed on repair areas of the weld between deck panel and edge panel (bike path side) OBG segment 6AE. Weld number was identified as CA026-002, 004, 006. Ultrasonic inspection performed utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 02082010-1.

No significant indication found

TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA Inspector randomly observed the following work in progress.

OBG SEGMENT 7WEST

This Quality Assurance (QA) Inspector observed ZPMC personnel performing magnetic particle inspection on root pass of deck panel splice weld between OBG segment 7BW and 7CW. During the magnetic particle inspection this Quality Assurance (QA) Inspector observed ZPMC NDT Inspector found a longitudinal linear indication. For more information see attached photo.

This Quality Assurance (QA) Inspector observed ZPMC personnel performed magnetic particle inspection on deck panel splice weld between OBG segment 6AW and 6BW. See attached photo.

CROSS BEAM # 6

This Quality Assurance (QA) Inspector observed ZPMC qualified welder 067665 performing Shielded Metal Arc Welding process for weld CB202-006-018 located on PCMK CB# 6 deck plate to side plate corner weld. ZPMC QC Mr. Wu Zhi Chang monitoring this welding. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-TC-U4B-FCM-1.

TRIAL ASSEMBLY YARD

ULTRASONIC INSPECTION

OBG SEGMENT 6BE

This Quality Assurance (QA) Inspector performed conventional UT (Ultrasonic Testing) in conjunction with ABF Ultrasonic Testing (UT) department for detection of planar transverse indication.

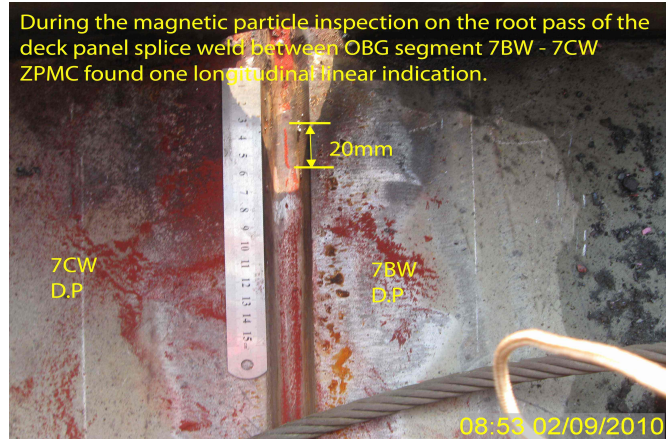
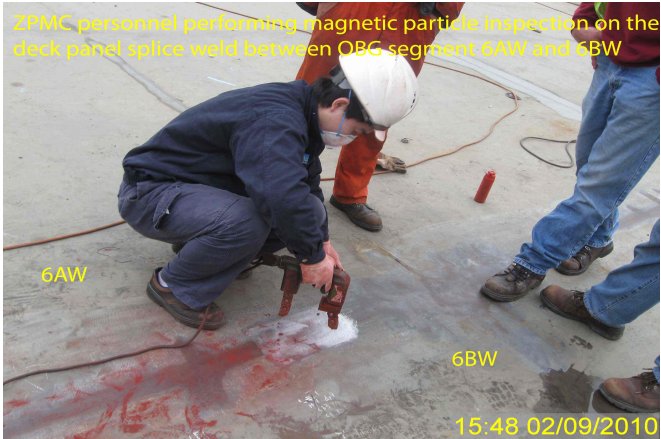
Ultrasonic Testing (UT) performed on repair areas of the weld between deck panel and edge panel (bike path side) OBG segment 6AE. Weld number was identified as CA028-002, 004, 006. Ultrasonic inspection performed utilizing scanning pattern A, B, C and D (Fig 6.7). American Bridge Fluor (ABF) request number was 02082010-1.

No significant indication found

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

WELDING INSPECTION REPORT

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, +(86) 1500 042 2372, who represents the Office of Structural Materials for your project.

Inspected By: Utekar,Shrikant

Quality Assurance Inspector

Reviewed By: Dawson,Paul

QA Reviewer